

Date: Thursday, 26/10/2006 8:30:36 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STA 155 BRACKET - UNDER REVIEW
Job Number	29182		<i>[Signature]</i>
Estimate Number	11040		
P.O. Number	N/A	Part Number	D28042
This Issue	26/10/2006	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2804 REV B
First Issue	N/A	Project Number	N/A
Previous Run	29169	Drawing Revision	UNDER REVIEW
Written By		Material	N/A
Checked & Approved By		Due Date	27/10/2006
Comment	Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wjetEC	Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061-T6B0500X12000	6061-T6 Bar .50" x 12.0"
	Comment: Qty.: 0.7875 f(s)/Unit Total : 0.7875 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	Batch: M100817 <i>M 08 10 26</i>
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: B Prog Rev: B	<i>M 08 10 26</i>
	2-Deburr if necessary	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	<i>J.F. 06/10/26</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>J.F. 06/10/26</i>
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>J.F. 06/10/26</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/16/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

J.F. 06/10/26

①

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 10 27

①

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 27

①

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/10/27

①

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/10/27

①

Job Completion



C Loc 110127

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 29182
Description:	Part Number: 2804-2
Inspection Dwg:	Rev: Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

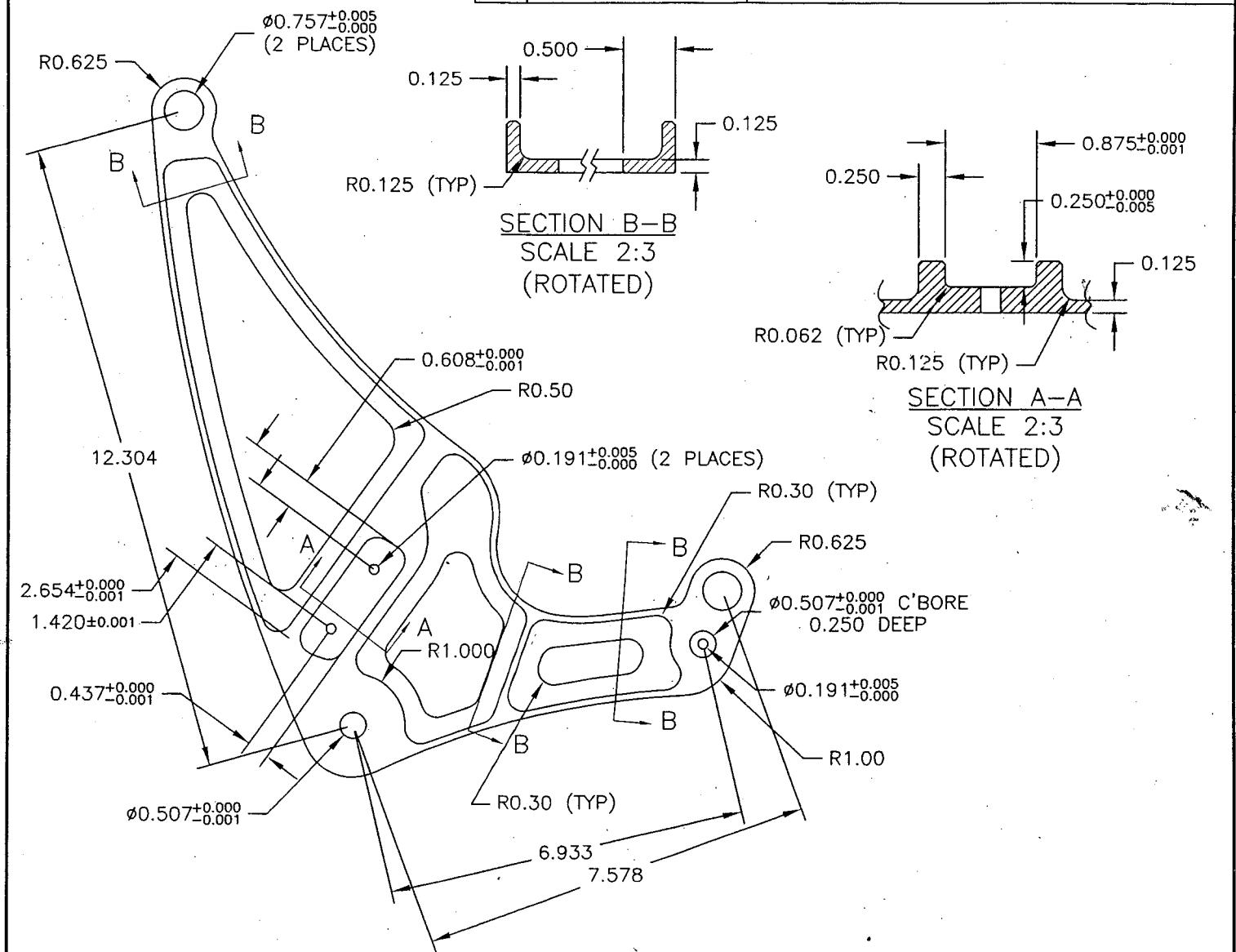
Measured by:	J.F.	Audited by:	S.G.	Prototype Approval:	N/A
Date:	06/10/26	Date:	06/10/26	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE				REV. C
06.10.16				SHEET 1 OF 2
				SCALE 1:3

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED